

# Work Order ID 107754

Monday, September 30, 2013 3:44:44 PM

**\*107754\***

Page 1

Item ID: D4000-11

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Cap

Start Date: 9/30/2013 Start Qty: 25.00

**\*25\***

Cust Item ID:

Required Date: 10/3/2013 Req'd Qty: 25.00

**\*25\***

Customer:

Reference:

Approvals:

Process Plan: *[Signature]*

Date: *13-09-30*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start **\*NR1\***

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D4000

A

100

0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

*6061.035*

Memo

1-Cut as per Dwg

Dwg Rev: *A*

Prog Rev: *A*

2-Deburr if necessary

0.00

*25*

*0*

*Ac*  
*13.00.01*

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

Memo

0.00

*25*

*0*

*Ac*  
*13.10.01*

**\*107754\***

Monday, September 30, 2013 3:44:44 PM

**Accept**

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**Start Date:** 9/30/2013      **Start Qty:** 25.00

**\*25\***

**Cust Item ID:**

**Required Date:** 10/3/2013      **Req'd Qty:** 25.00

**\*25\***

**Customer:**

**Reference:**

**Approvals:**      **Process Plan:** \_\_\_\_\_      **Date:** \_\_\_\_\_      **Tooling:** \_\_\_\_\_      **Date:** \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

120 QC8- Inspect parts - second check

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

170

Identify as per dwg & Stock Location: WA003 0.00

0.00

**\*170\***

### Packaging

## Memo

0.00

## Packaging

180

QC21- Final Inspection - Work Order Release	0.00
---	------

0.00

**\*180\***

QC

## Memo

0.00

## Quality Control

25 B10-01 DA 09 0-89

25 13-10-01

49 / 11 (3-102)

113-102

# Picklist Print

Monday, September 30, 2013 3:44:43 PM

Page 1

Work Order ID: 107754

Parent Item: D4000-11

Parent Item Name: Cap

Start Date: 9/30/2013

Required Date: 10/3/2013

Start Qty: 25.00

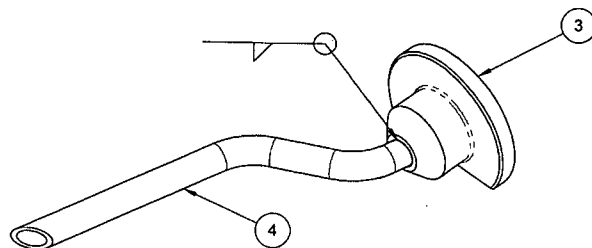
Required Qty: 25.00

Comments: IPP rev A 10.02.03 new issue Prelim EC verified by:DD IPP rev B 10.05.13 ecn10-562  
EC verified by:DD

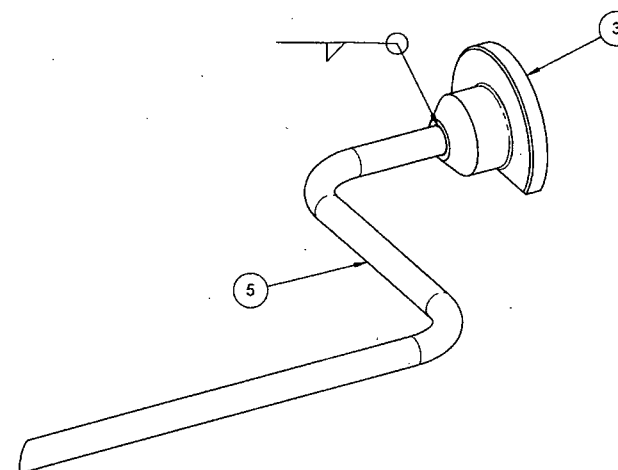
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	868.7060	0.001	<del>0.025</del> 0.1		Jm13-09-30	
				<u>Location</u>		<u>Loc Qty</u>	<u>Loc Code</u>						
				MAT021		868.706							
				123483		256.6							
				m125822		59.1							
				m126115		64.856							
				m126147		232.54							
				m126309		255.61							
										126147.			



ITEM	QTY. -043	QTY. -045	P/N	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X		D4000-041	DRAIN FITTING ASSEMBLY, AFT	JCA-M47-1-06
2		X	D4000-043	DRAIN FITTING ASSEMBLY, FWD	JCA-M47-1-15
3	1	1	D4000-3	FUEL SUMP DRAIN FITTING	
4	1		D4003-1	INTERNAL DRAIN LINE, AFT	
5		1	D4003-3	INTERNAL DRAIN LINE, FWD	



**D4000-041 DRAIN FITTING ASSEMBLY, AFT**



**D4000-043 DRAIN FITTING ASSEMBLY, FWD**

**RELEASED**  
2010-05-05  
MP

**NOTES:**

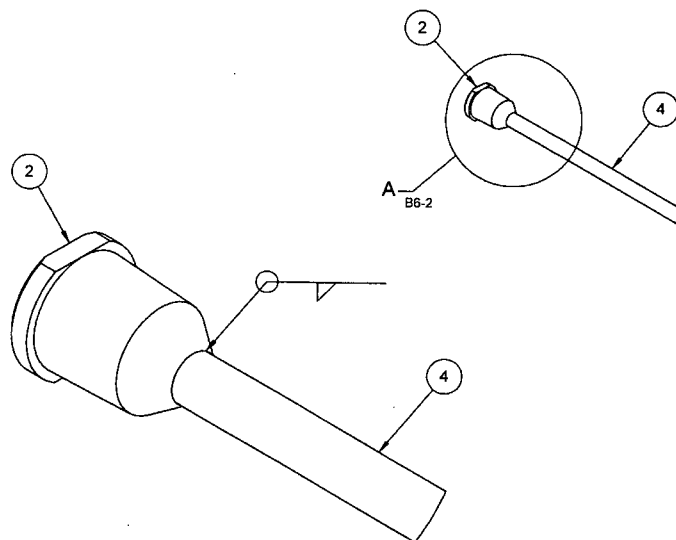
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-043/-045" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: D4000-043 - 0.04 lbs  
D4000-045 - 0.05 lbs

A	NEW ISSUE		10.02.10
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
DE APPR.			
DATE	10.02.10		

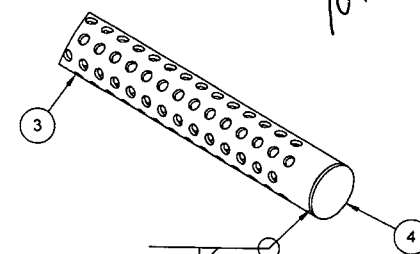
  

<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. <b>D4000</b>	REV. A
TITLE <b>FITTING</b>	SCALE NTS
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ITEM NO.	QTY. -047	PART NUMBER	DESCRIPTION	JOHN CAMERON AVIATION PART NUMBER
1	X	D4000-045	FUEL PICK UP FITTING ASSEMBLY	JCA-M47-1-10
2	1	D4000-7	FUEL PICK UP FITTING	
3	1	D4000-11	CAP	
4	1	D4003-5	FUEL PICK UP LINE	



**DETAIL A**  
SCALE 4X C6-2



**DETAIL B**  
SCALE 4X B2-2

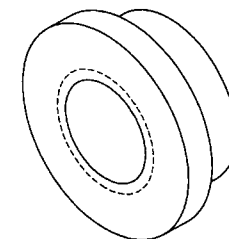
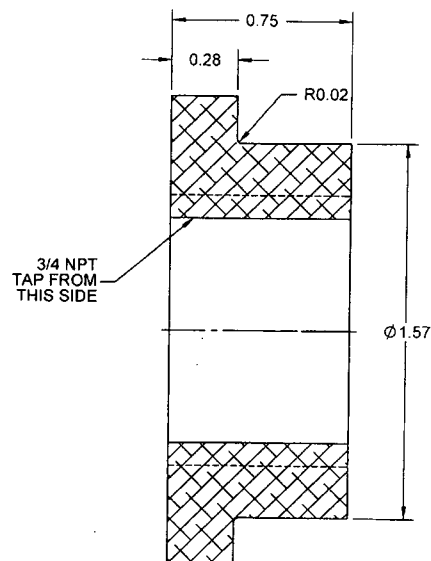
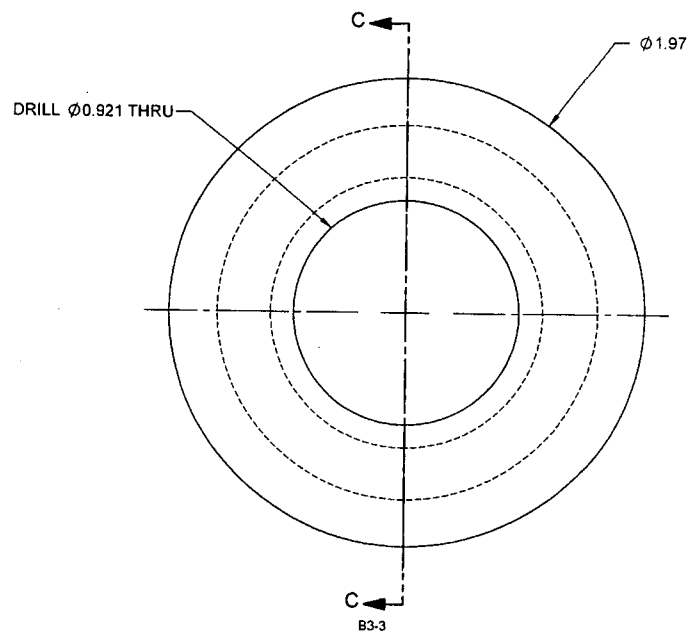
**D4000-045 FUEL PICKUP FITTING ASSEMBLY**

**RELEASED**  
2010-05-05

- NOTES:**
- 1) MATERIAL: N/A
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4000-045" AND B/N USING FINE POINT PERMANENT INK MARKER
  - 7) WEIGHT: 0.27 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 2 OF 8
APPROVED		TITLE	SCALE
DE APPR.		FITTING	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-1	JCA-M47-1-04



107754

# **D4000-1 FUEL SUPPLY FITTING**

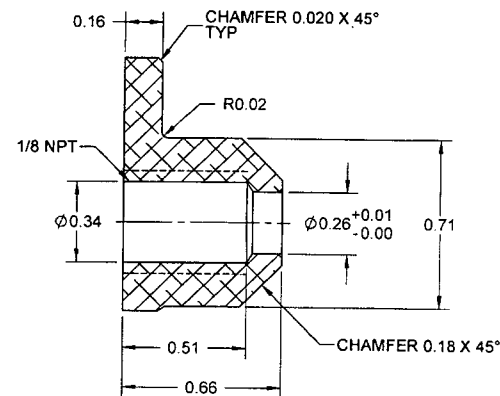
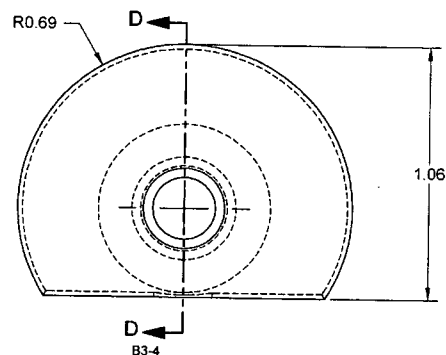
**RELEASED**  
2010-05-05  
MJP

## **NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.12 lbs

DESIGN	JE	<b>DART AEROSPACE LTD</b>	
DRAWN	JE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	JE	DRAWING NO.	REV. A
MFG. APPR.	JE	<b>D4000</b>	SHEET 3 OF 8
APPROVED	JE	TITLE	SCALE
DE APPR.	JE	<b>FITTING</b>	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-3	JCA-M47-1-05



SECTION D-D  
B6-4

**D4000-3 FUEL SUMP DRAIN FITTING**

**RELEASED**  
2010-05-05  
WJP

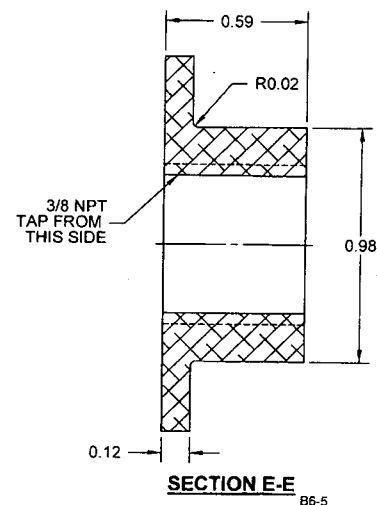
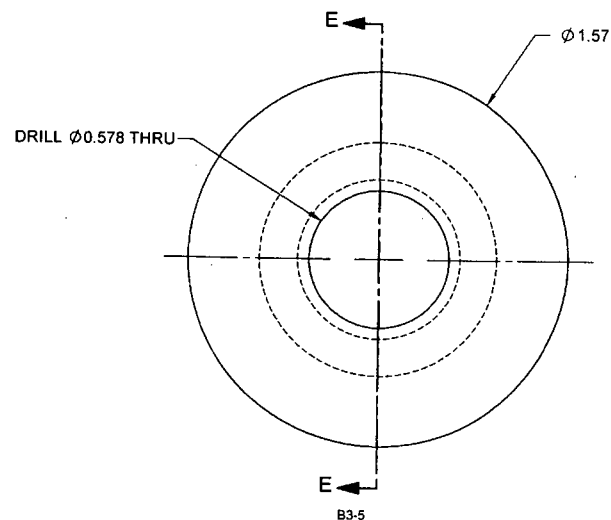
**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS4160)  
REF DART SPEC M6061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4000</b>	REV. A
MFG. APPR.			SHEET 4 OF 8
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DE APPR.			NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-5	JCA-M47-1-09



107754

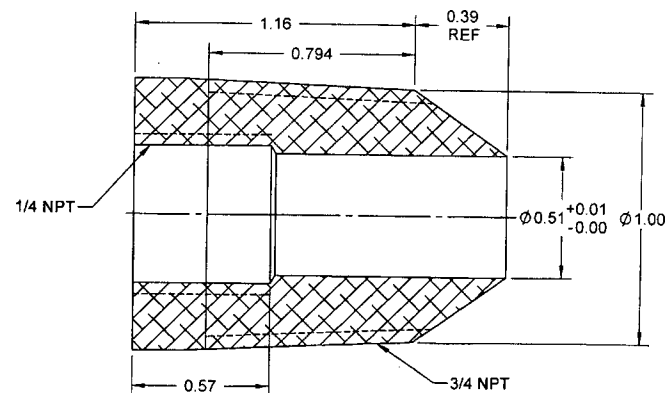
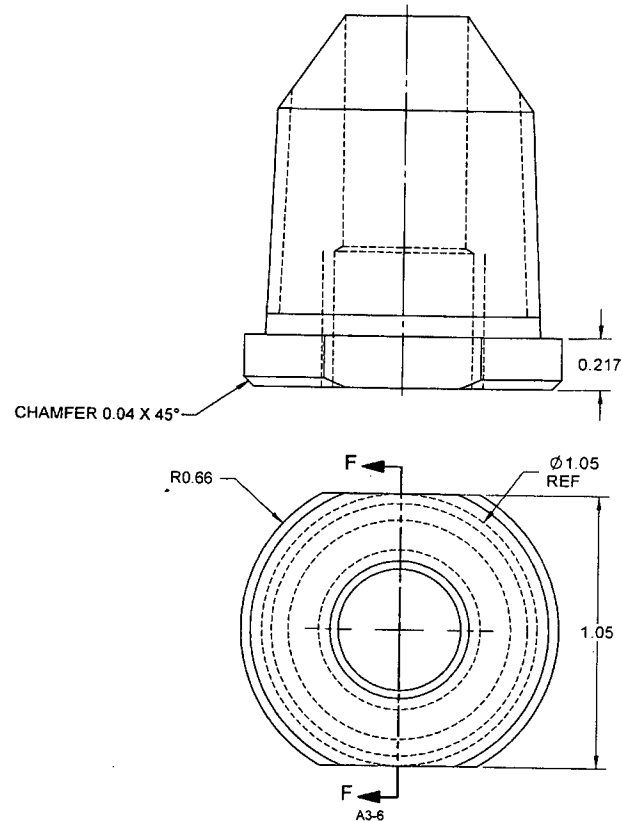
# **D4000-5 FUEL TANK VENT FITTING**

**RELEASED**  
2010-05-05  
*MD*

- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M6061T6R
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 0.04 lbs

DESIGN	<i>JS</i>	<b>DART AEROSPACE LTD</b>	
DRAWN	<i>JS</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>JS</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>JS</i>	D4000	SHEET 5 OF 8
APPROVED	<i>JS</i>	TITLE	SCALE
DE APPR.	<i>JS</i>	FITTING	NTS
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DART AEROSPACE PART NUMBER	JOHN CAMERON AVIATION PART NUMBER
D4000-7	REF JCA-M47-1-10



SECTION F-F

A6-6

**D4000-7 FUEL PICK UP FITTING**

**RELEASED**  
2010-05-05

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF DART SPEC M5061T6R
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D4000</b>	REV. A
MFG. APPR.			SHEET 6 OF 8
APPROVED		TITLE <b>FITTING</b>	SCALE
DE APPR.			NTS
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DART AEROSPACE  
PART NUMBER

D4000-9

JOHN CAMERON AVIATION  
PART NUMBER

JCA-M47-1-11

DRILL  $\phi 0.60$  THRU

$\phi 1.02$

G

G

B3-7

0.13 x 45° CHAMFER

0.39

$\phi 0.709$   $\phi 0.748$

0.051

0.20 0.073

SECTION G-G

B6-7

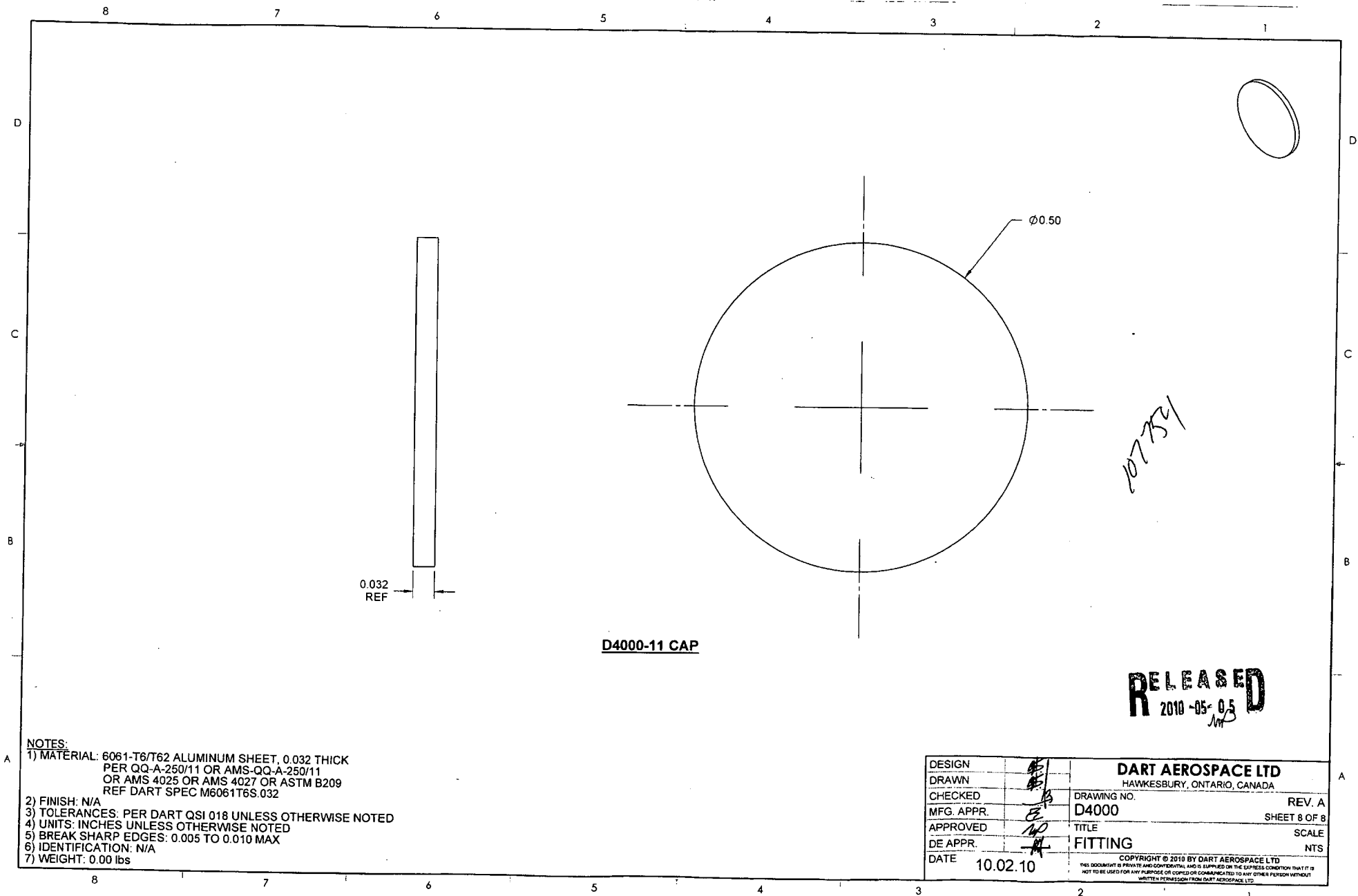
D4000-9 GROMMET

**RELEASED**  
2010-05-05

**NOTES:**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL,  $\phi 1.000$  ROUND BAR  
REF DART SPEC M-DELRIN-R1.000
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		<b>D4000</b>	SHEET 7 OF 8
APPROVED		TITLE	SCALE
DE APPR.		<b>FITTING</b>	NTS
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NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.032 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M6061T6S.032
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.00 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4000	SHEET 8 OF 8
APPROVED		TITLE	SCALE
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